

303 1"

Work Order ID 154174

Tuesday, December 06, 2016 1:18:58 PM

154174

Page 1

Item ID: D4151-5 **Accept** ***N900040100*** **Setup** **Start** ***NS1***
Revision ID: **Stop** ***NS2***
Item Name: Fwd Basket Instl Stud
Start Date: 11/30/2016 **Start Qty:** 12.00 ***12*** **Cust Item ID:**
Required Date: 12/6/2016 **Req'd Qty:** 12.00 ***12*** **Customer:**
Reference:

Approvals: **Process Plan:** DAS **Date:** DEC 08 2016 **Tooling:** **Date:** **Run** **Start** ***NR1***
QC: 21 **Date:** **SPC (Y/N):** **Date:** **Stop** ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4151	C

110

0.00

110

Doosan

Memo

0.70

Doosan Lathe

1-Mill as per folio FA953 & dwg ,

FOLIO REV: AADWG REV: C

2-Deburr as required

12

16-12-20

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.02

Quality Control

12

16-12-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval 	
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐								
Misidentified	☐	Past Due	☐	OTHER :							

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Page 2

Item ID: D4151-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Fwd Basket Instl Stud

Start Date: 11/30/2016 Start Qty: 12.00

12

Cust Item ID:

Required Date: 12/6/2016 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run

Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.04

Quality Control

12

Ø

DAS

44

9-89/6-12-23

140

Identify as per dwg & Stock Location: 5087

0.00

140

Packaging

Memo

0.02

Packaging

12

JAN 06 2017

DAS

6

9-89

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.20

Quality Control

DAS

21

9-89

JAN 06 2017



JAN 06 2017

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Picklist Print

Tuesday, December 06, 2016 1:18:58 PM

Page 1 / 1

Work Order ID: 154174

154174

Parent Item: D4151-5

D4151-5

Parent Item Name: Fwd Basket Instl Stud

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP Rev:B
11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R1.000		Purchased	No			110	f	14.6000	0.25	3.157895			

M303R1 000

303 Round Bar 1.00

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT028	14.6	
m135612	2.6	
m136036	12	

M136327

4' 816-12-20

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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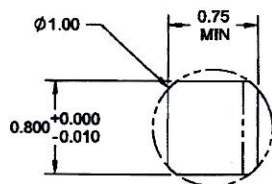


WORK ORDER NON-CONFORMANCE / UPDATE

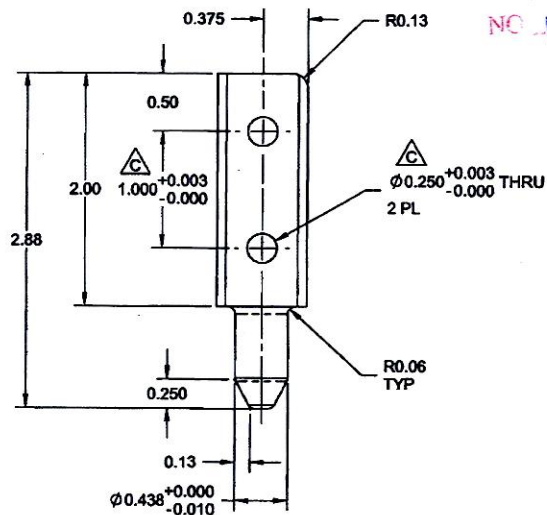
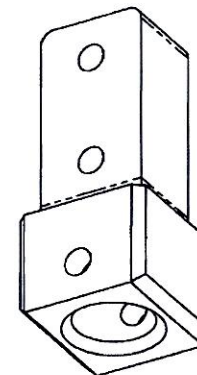
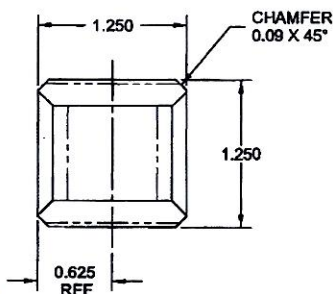
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Work Order update only ☐

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OTHER : _____																					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154174 MLS



16-12-03

1.00

0.125 REF

0.500 REF

R0.13 2 PL

A

Ø0.250 $\begin{matrix} +0.003 \\ -0.000 \end{matrix}$ THRU 2 PL

R0.19 4 PL

1.000 $\begin{matrix} +0.003 \\ -0.000 \end{matrix}$

2.84 REF

1.110

0.96

0.350

CHAMFER 0.09 X 45° 2 PL

A

SYMM

Ø0.257 THRU

Technical drawing of a mechanical part, likely a bush or sleeve, showing a cross-section. The part has a central hole with a diameter of $\phi 0.734^{+0.010}_{-0.000}$. The outer diameter is $0.800^{+0.000}_{-0.010}$. The total height is 1.88 inches. The part features a chamfer of 0.09 inches at a 45-degree angle. The drawing includes a centerline and a symmetry symbol (SYMM). The part is divided into sections with cross-hatching and horizontal lines.

RELEASED
2011-06-23
RELEASED

- 2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN	<i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4151 TITLE BASKET FWD HARDPOINT COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED UNDER A LICENSED AGREEMENT. IT MAY NOT BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD. NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	REV. 0
DRAWN	<i>JS</i>		SHEET 3 OF 3
CHECKED	<i>SC</i>		SCALE
MFG. APPR.	<i>MB</i>		NTS
APPROVED	<i>MB</i>		
DE APPR.	<i>H</i>		
DATE	10.12.14		

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

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